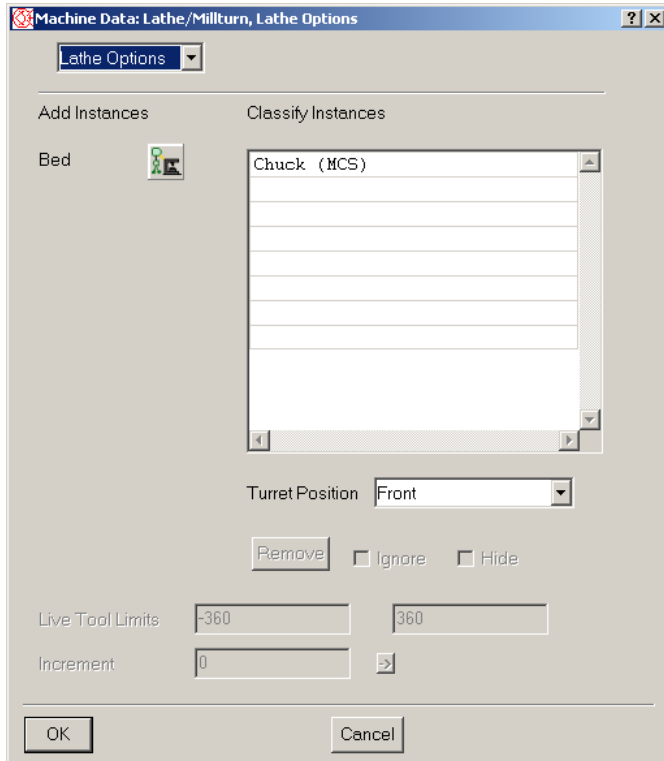


## Notes on Preparing I-DEAS Lathe Jobs for the Haas TL1 Lathe

The TL1 lathe has the tool post mounted in front. Bring up the Machine Data icon,



switch to “Lathe Options” and switch the Turret Position to “Front”



Use the tools from the EM433 – CAM project that have TL1 in the tool name. The following tools are available:

Description	Tool Name	Post Tool ID
35deg. diamond turning tool, right-hand	35TT-R-TL1	1
35 deg. diamond turning tool, left-hand	35TT-L-TL1	2
60 deg. threading tool, right-hand	60THR-A-TL1	3
0.125 in. wide grooving tool, right-hand	GR-R-TL1	4

You typically use a right-hand tool when feeding towards the headstock on a front turret lathe. The spindle direction should be counter-clockwise for using all of the tools listed above.

### Cutting Parameters:

For roughing operations, set the max. depth of cut to 0.050 in. For Feeds/Speeds, check the “Use tools defaults” box. The diameter and face allowance should be set to 0.010 in.

For finish turning, set the feed to 0.003 IPR and the speed to 1800 RPM